

Abstract

A method of producing a gas generator housing part of a thin-walled tube (22, 24) and a connecting piece laterally mounted thereto, is characterized by the following steps: a) providing a tube (22, 24) having a wall thickness (WS) which amounts to a maximum of 10 % of a tube external diameter (D) and a minimum tensile strength which amounts to at least approximately 800 N/mm²; b) providing a connecting piece having an external diameter (do) which amounts to between 15 % and 40 % of said tube external diameter (D); c) aligning said connecting piece radially to said tube (22, 24) such that an end face (78) of said connecting piece faces an outer face of said tube (22, 24); d) joining said tube (22, 24) and said connecting piece by friction welding, with producing a relative rotation between said tube (22, 24) and said connecting piece and moving said tube (22, 24) and said connecting piece towards each other, f) a maximum welding time amounts to less than 1 sec, preferably less than 0.3 sec and g) a friction depth (h) amounts to less than 80 % of said wall thickness (WS) of said tube (22, 24). This method provides a friction welding process in which the friction depth is less than the wall thickness of the tube (22). There is further proposed a gas generator produced by such method and a gas bag module including such gas generator.

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